

Thursday, 5/31/2007 7:21:03 AM
Kim Johnston

Process Sheet

Split
SD 07/06/11

24

| | | | | | |
|-----------------------|---------------------------------------|--|------------------|---------------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : HELI-ACCESS STEP RH (FOLDING) | |
| Job Number | : 32714 -2 | | | SPLIT -2 | |
| Estimate Number | : 12568 | | Part Number | : D412630034 | |
| P.O. Number | : JIA | | Drawing Number | : IIN D412-630 REV K | |
| This Issue | : 5/31/2007 S.O. No. : N/A | | Project Number | : N/A | |
| Prsht Rev. | : NC | | Drawing Revision | : K | |
| First Issue | : N/A | | Material | : JIA | |
| Previous Run | : 29385 | | Due Date | : 6/11/2007 | |
| Written By | | | Qty: | 5 Um: Each | |
| Checked & Approved By | : 07.05.31 | | | | |
| Comment | : Est. Rev.A New Issue 06-11-08 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|---|
| 1.0 | DC | DOCUMENT CONTROL |
|  | | |
| | | Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG002 |
| 2.0 | D2012107 | Clevis |
|  | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: → Qty Part Number Description Batch 1 D2012-107 Clevis B29883 | | |
| 3.0 | D2803042 | Bracket Assembly |
|  | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2803-042 Bracket Assembly RH B29392 | | |
| 4.0 | D2804042 | Bracket Assembly |
|  | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2804-042 Bracket Assembly RH B26252, 7/14/08 | | |

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|----------|------|--------------------|-----|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/06/11 | 18 | Split | u/o | | SB | 07/06/11 | 1 | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector | |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

5.0 D2807



Support Prop

Description :



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Support Prop

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | D2807 | Gas Spring | 1528487 |

Washer

6.0 D2813



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | D2813 | Washer | 1525923 |

STEP ASSEMBLY, RH

7.0 D3562042



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Step Weldment LH

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|------------------|---------|
| 1 | D3562-042 | Step Weldment RH | 1525923 |

8.0 D33951



Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)
Bushing

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------------------------|
| 4 | D3395-1 | Bushing | 1527291, 1525935, 1524770 |

9.0 AN3C21A



BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
BOLT

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------------------|
| 2 | AN3C21A | Bolt | 1519633, 15261489 |

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

(5)

Pick:

Qty

Part Number

Description

Batch

M100695

11.0 AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut



Pick:

Qty

Part Number

Description

Batch

M100433

12.0 MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty

Part Number

Description

Batch

M16941

13.0 NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

M19633

14.0 NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty

Part Number

Description

Batch

M103286 76/4 SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

15.0 NAS1515H8



Washer

Description :



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 4 | NAS1515H8 | Washer | <i>M102067</i> |

Nut

16.0 MS210433



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 4 | MS21043-3 | Nut | <i>M103691</i> |

Screw

17.0 MS24693C280



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------------------|----------------|
| 2 | MS24693-C280 | Screw (or MS24694-C565) | <i>M101390</i> |

18.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1

7/6/450



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: *M101472*

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: *M17045*

MF 07-06-12 ①

19.0 QC5



INSPECT WORK TO CURRENT STEP



SB 07/06/12 ①

Comment: INSPECT WORK TO CURRENT STEP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

m29393

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

b29394

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

b27287

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

b27290

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M102039

7/6/450

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4C10A Bolt

M100273

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4C15A Bolt

M101291

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number Description Batch

1 AN44-C7A Eyebolt

M10171

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5C15A Bolt

M100229

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

7 NAS1515H4 Washer

M101428 7/6/4 54

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32714

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer



Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

32.0 MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M104537



33.0 MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M101418

7/6/459 (3)

34.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0 PACKAGING 1

PACKAGING RESOURCE #1



7/6/12 (1) 2010612 (1)

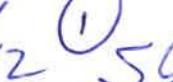


Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: _____

PPP Rev: _____



36.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

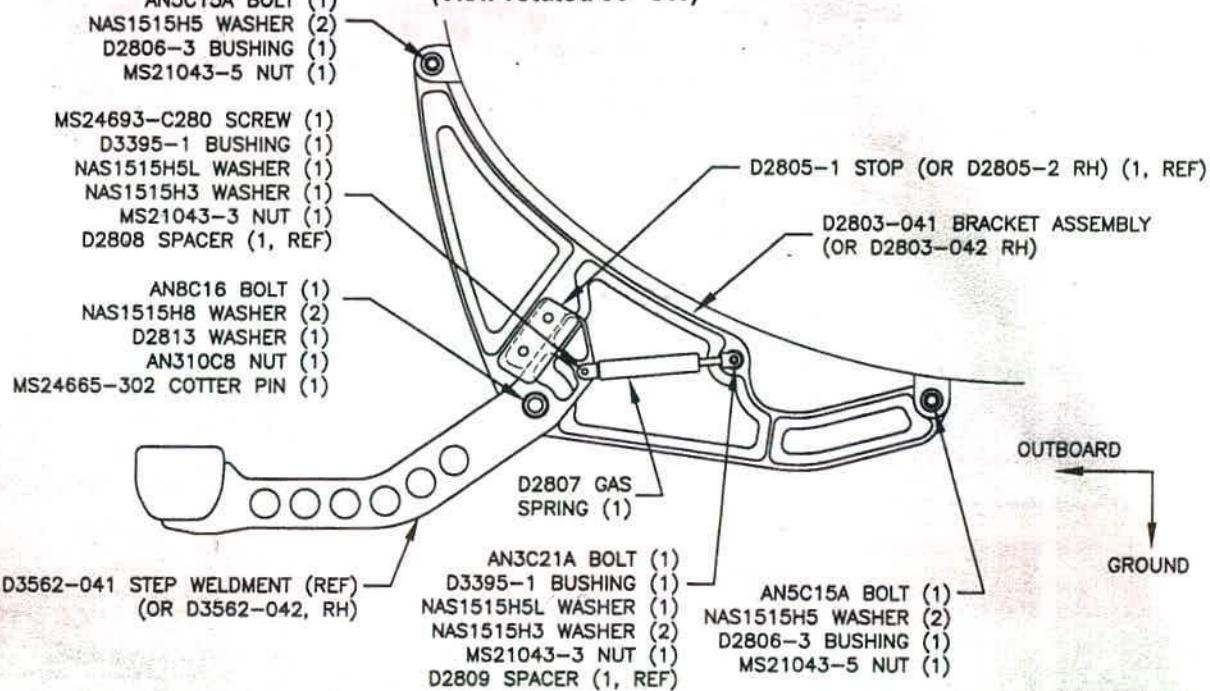
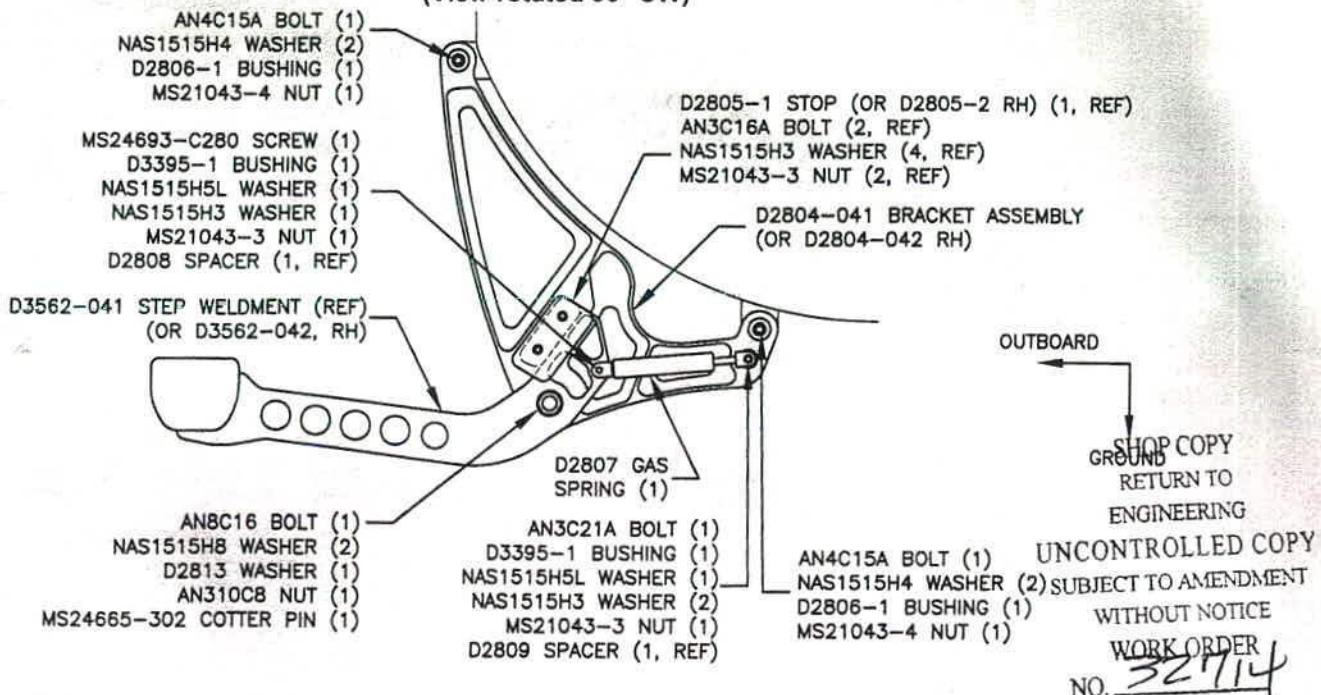


7/07/06/12 (1)

Job Completion



7/6/12

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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